



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

SWA10A-300
Job Sheet 181584



Part No: SWA10A-300

Job Qty: 10 ea

Part Name: Bearing Housing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/1/18

Job Tracking No:

Due Date: 8/27/18

Created By: Logan David

Type: Stock

Description:

Note: DWG SWA10A-300 Rev 5 IPP Rev A 17.12.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	8/27/18	8/27/18	0.00	0.00	Start Up Machining-3		
100	Bandsaw	10 pcs	8/27/18	8/27/18	0.00	1.00	Bandsaw1		
110	Mori Seiki	10 pcs	8/27/18	8/27/18	0.00	10.00	MORI NLX		
120	QC	10 pcs	8/27/18	8/27/18	0.00	0.00	QC2		
130	QC	10 pcs	8/27/18	8/27/18	0.00	0.00	QC8		
140	Packaging	10 pcs	8/27/18	8/27/18	0.00	0.00	Packaging3		
150	QC21-SA	10 Ea	8/27/18	8/27/18	0.00	0.00	QC21		

Part Op 100 - Cut Blanks to 3.560"

Descriptions: 110 - 1-Machine as per DWG. FB711 FOLIO REV: AA DWG REV: 5 2-Debur

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R4.000	17-4 SS H1150 Round Bar 4.000"	3 ft (.3 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H1150-R4.000	3	12	0

Part Specifications

Specifications could not be found.

Plex 8/1/18 9:06 AM dart.logan.david



Container No: S099122



Part: SWA10A-300

Job No: 181584

Serial No/Batch: S099122

Revision: 5

Inspector:

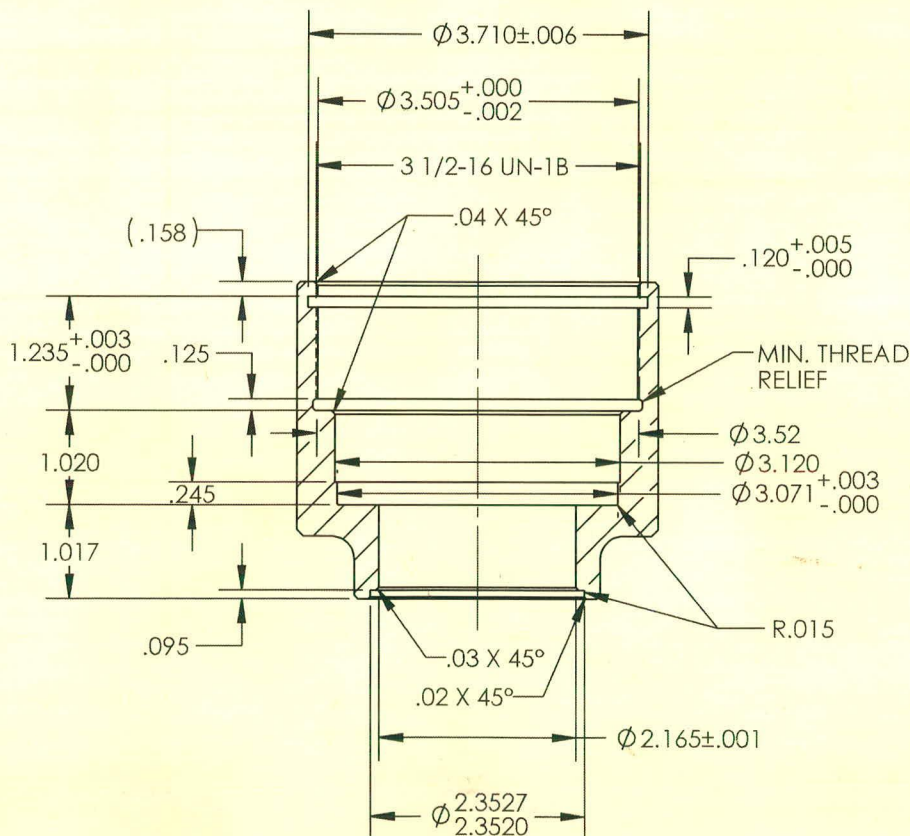
Exp Date:

Instructions:

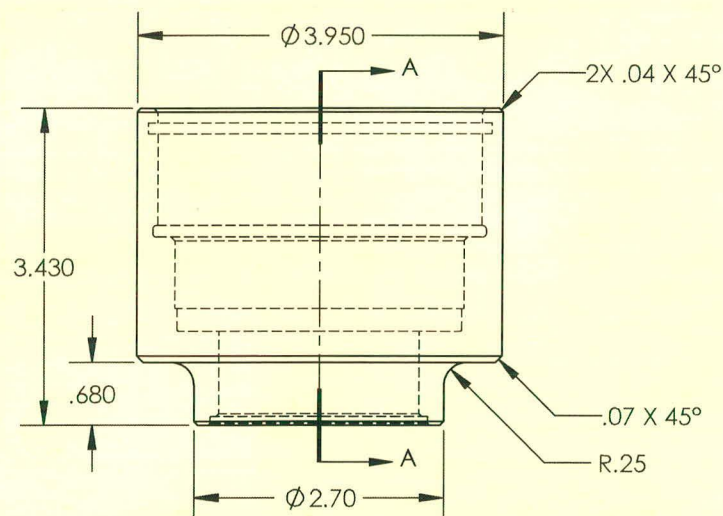
Date: 08/03/18

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REVISIONS					DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION					
2		AS DRAWN BY CANAM			11/12/2012	JAG	
3		CH'D TOLERANCE OF Ø2.352+.003/-0.000 TO A LIMIT DIM.			11/16/2012	JAG	
4	15-0304	UPDATED TO NEW DRAFTING STANDARDS. ADDED MATL OPTION H1075.			10/16/2015	DPD	JAG
5	16-0252	CH'D THREAD DIM WAS 3-1/2-16 UN-2B IS 3-1/2-16 UN-1B, ADDED MIN. THREAD RELIEF NOTE.			12/5/2016	RJC	JAG



SECTION A-A



DART AEROSPACE	
TITLE BEARING HOUSING	
DWG NO. SWA10A-300	REV 5
MAT'L SS 17-4 H1150/H1075	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: CANAM	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	
SCALE 1:2	DATE 2/21/2002
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			SWA10A-300	1	BEARING HOUSING	SS 17-4 H1150/H1075	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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DART AEROSPACE LTD		Work Order:	178639/18/584
Description: Bearing Housing		Part Number:	SWA104-300
Inspection Dwg: SWA104-300	Rev:	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 3.710	±.006	3.7105	/		mic 112-177	
Ø 3.505	+.000/- .002	3.504	/		mic 104-137	
3/2 -16UN 1B	G-0 / NOGO	G-0	/			
.04 x 45°	±.01 x .5°	.04 x 45°	/			
1.235	±.003/- .000	1.235	/			
1.020	±.005	1.019	/			
.245	±.005	.245	/			
1.017	±.005	1.018	/			
.095	±.005	.095	/			
.03 x 45°	±.01 x .5°	.03 x 45°	/			
.02 x 45°	±.01 x .5°	.02 x 45°	/			
Ø 2.165	±.001	2.1648	/		mic V-6	
Ø 2.3520/2.3521		3.5204	/			
Ø 3.071	+.005/- 0.000	3.069	/		mic 104-137	
Ø 3.120	±.005	3.119	/			
Ø 3.52	±.01	3.520	/			
.120	±.005/- .000	.1204	/		mic	
Ø 3.950	±.005	3.9505	/		mic 104-137	
3.430	±.005	3.430	/			
.680	±.005	.680	/			
Ø 2.70	±.01	2.700	/			
.04 x 45°	±.01 x .5°	.04 x 45°	/			
.07 x 45°	±.01 x .5°	.07 x 45°	/			
.25	±.01	.25	/			

Measured by: JL	Checked by: J.A.	QC Inspector:	
Date: 18-8-2	Date: 18-08-14	Date:	

Engineering Approval: (If necessary)	Date:
---	-------

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

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